

# Work Order ID 56398

February 22, 2010 12:56:49 PM



Page 1

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 2/22/10 Start Qty: 8.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

*RE*

Date: 10-2-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2574

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

0.00

HAAS CNC vertical machine #1

Memo

Program Batch No. 56398 Double check by: BA ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and insp

*10.2.25*  
*B.A 10/02/27*

8

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

0.00

Conventional Milling Machine

Memo

Machine keyway as per dwg D2573 & D2574

*B.A 10/02/27*

8

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

0.00

Quality Control

Memo

*B.A 10/02/27*

8

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SA 10/03/01

8 0

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

el 10/03/02

(X8) 0

150

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M113170

=> W 10/03/02

(X8) d

START TIME: 2:00pm FINISH TIME: 2:30pm OVEN TEMPERATURE: 320F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56398**

February 22, 2010 12:56:49 PM

Page 3

Item ID: D2574

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Aft In 205

Start Date: 2/22/10 Start Qty: 8.00

Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-03-2  
10-03-3  
10-03-05  
mf 10-3-3

# Picklist Print

February 22, 2010 12:56:54 PM

Page 1

Work Order ID: 56398



Parent Item: D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 2/22/10

Required Date: 3/08/10

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	114.0000	8.0000			
Saddle Billet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

46411

114

114

8.0000

M.A 10/01/27

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 56398
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 2</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	7.999	7.999		
F	0.490	0.510		0.504	0.506	0.503	0.502		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.497	0.499	0.497		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	0.565	0.564	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.126	0.126	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.245	0.253	0.252	0.253		
S	0.115	0.135		0.127	0.131	0.128	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		0.240	0.242	0.240	0.241		
W	0.115	0.135		0.130	0.135	0.134	0.132		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.763	0.763	0.763	0.764		
Z	0.352	0.372		0.363	0.365	0.364	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.627	0.629	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.255	0.253	0.253		
AE	1.500	1.520		1.513	1.510	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.275	0.275	0.275	0.275		
AH	0.240	0.260		0.245	0.254	0.252	0.251		
AI	2.000	2.020		2.002	2.000	2.002	2.003		
AJ	0.023	0.043		0.040	0.040	0.040	0.040		
Accept/Reject									

Measured by: B.A
Date: 10/02/27

Audited by: SA
Date: 10/03/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 56398
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page</b> 1 <b>of</b> 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

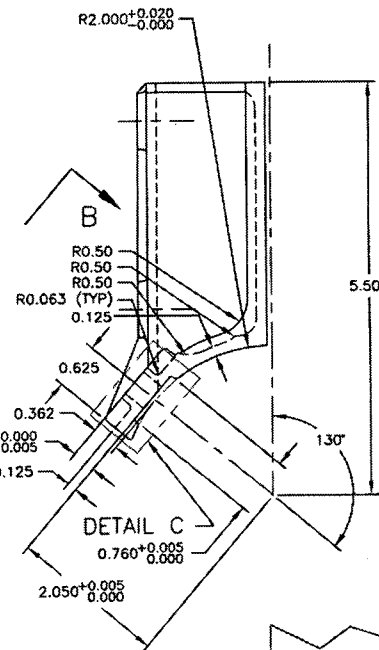
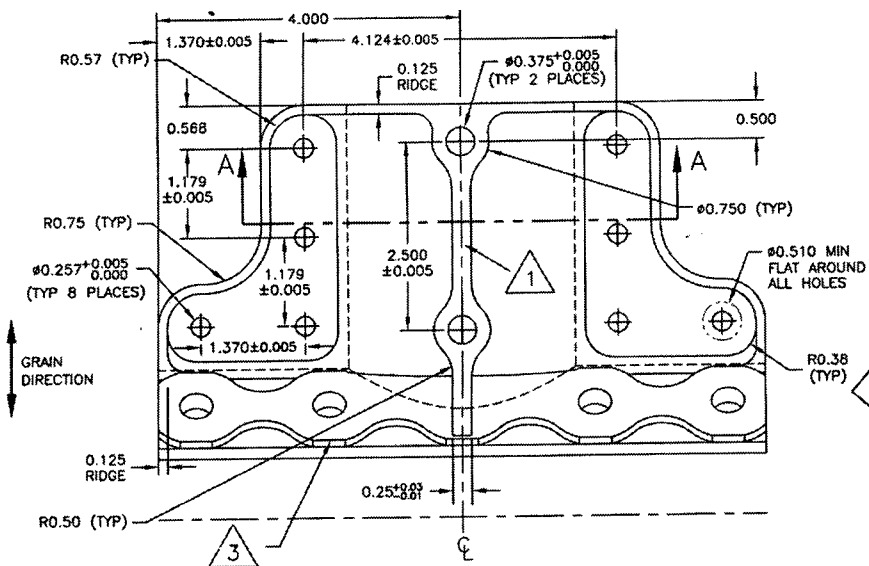
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.999	7.999	8.000		
F	0.490	0.510		0.500	0.503	0.500	0.496		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.499	0.499	0.496		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	0.564	0.564	0.564		
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O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.126	0.125	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.251	0.253	0.252		
S	0.115	0.135		0.12	0.132	0.128	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.233	3.233	3.233	3.233		
V	0.230	0.250		0.240	0.242	0.239	0.241		
W	0.115	0.135		0.133	0.131	0.131	0.133		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.764	0.764	0.764	0.763		
Z	0.352	0.372		0.366	0.366	0.366	0.366		
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AB	0.615	0.635		0.628	0.629	0.629	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.245	0.242	0.243		
AE	1.500	1.520		1.511	1.510	1.512	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.275	0.275	0.275	0.275		
AH	0.240	0.260		0.251	0.251	0.254	0.252		
AI	2.000	2.020		2.002	2.000	2.002	2.002		
AJ	0.023	0.043		0.040	0.040	0.040	0.040		
Accept/Reject									

Measured by: B.A	Audited by: SA
Date: 10/02/27	Date: 10/02/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



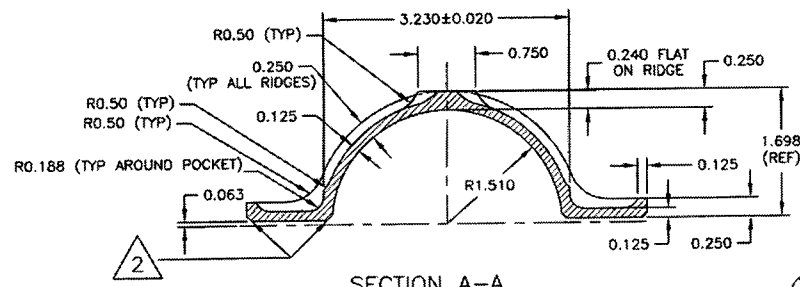
05.12.06 *th*



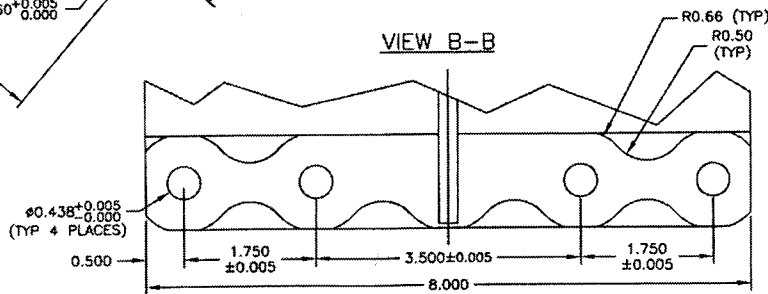
## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

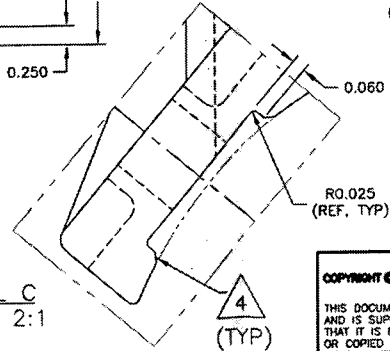
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)
- E



SECTION A-A




VIEW B-B



DETAIL C  
SCALE 2:1

SHOP COPY  
RETURN TO  
ENGINEER  
UNCONTROLLED  
SUBJECT TO  
WITHOUT  
WORK

WITHIN  
WORK ORDER  
NO. 56398  
BY 10-2-22

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN	DRAWN BY	 <b>DART AEROSPACE, LTD.</b> HARBESBURY, GERRING, CHAMPS	
DS	PH		
CHECKED	APPROVED	DRAWING NO. D2574	REV. E SHEET 1 OF 1
DATE		TITLE INNER AFT SADDLE	SCALE 2:3
05.07.13			